How to Fix a Cross Threaded or Stripped Hole in Aluminum

A free repair guide for users who have stripped the threads in a hole of an aluminum part and need to re-tap it.

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INTRODUCTION

How to re-thread a stripped or mis-threaded aluminum hole.

TOOLS:
- Cut Tap (1)
- Tap Handle (1)
Step 1 — How to Fix a Cross Threaded or Stripped Hole in Aluminum

- Determine which hole has the cross threaded or stripped screws.

- Determine the size of the current thread. Threads are called out by the outer diameter, a dash, and then the thread count. For example, the tap shown is 1/4"-20".

  The hole’s outer diameter can be determined by measuring the width of the screw or bolt that goes into the hole.

  The thread count can be determined by counting the number of threads in one inch of screw length.

- Select the appropriate tap size.

 ⚠️ Taps are sharp. Do not handle the teeth.

- Install the tap into the tap handle (See photo).
Step 2

- Align the tap attached to the tap handle over the cross threaded or stripped hole.

- For right hand screws, insert tap into tap hole as you slowly rotate the tap handle clockwise.

  99 percent of holes, screws, and bolts are right hand screws. If you know your hole is a left hand thread, rotate counterclockwise instead of clockwise.

Step 3

- Rotate the tap handle clockwise two full rotations, then counterclockwise 1/4 of a turn.
Step 4

- Repeat step three until you cannot easily rotate the tap handle clockwise anymore.
- Rotate the tap handle counterclockwise until the tap is out of the part.

After re-tapping your miss threaded check to make sure the threads work by screwing in the bolt or screw the hole is intended for